

Work Order ID 86448

June-29-12 8:05:53 AM

Ship today 29/06

86448

Page 1

Item ID: D4422-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Shim

Start Date: 6/29/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/29/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: h Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4422	A

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Shear as per dwg D4422

10 10 12-06-29

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

10 10 12/06/29

115

Chemical Conversion Coat per QSI005 4.1

0.00

115

HandFinish

Memo

0.00

Hand Finishing

10 10 12/06/29

Picklist Print

June-29-12 8:05:53 AM

Page 1

Work Order ID: 86448

Parent Item: D4422-1

Parent Item Name: Shim

Start Date: 6/29/12

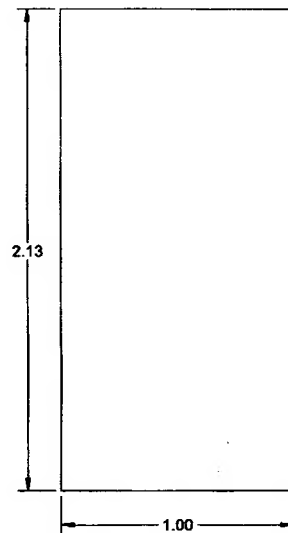
Required Date: 6/29/12

Start Qty: 10.00

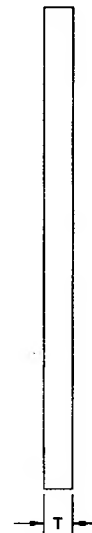
Required Qty: 10.00

Comments: IPP revA 11.06.30 new issue ec verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date issued	Status
M6061T6S.125 6061-T6 .125 Sheet		Purchased	No				sf	33.4576		0.1694737	10	FF 12-06-29	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT021		33.4575526							
				121473		33.4575526							
											0.1694737		



D4422-X SHIM



P/N	T THICKNESS
D4422-1	0.125
D4422-3	0.063

NOTES:

1) MATERIAL:

- D4422-1: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
OR
6061-T6/T651/T6510/T6511/T62, 0.125 X 1.000, PER QQ-A-225/8
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6S
D4422-3: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4422-X" AND B/N PER QSI 044 6.1
7) WEIGHT: D4422-1 = 0.01 lbs; D4422-3 = 0.01 lbs

w/o 86448

RELEASED
2011-07-06

A	NEW ISSUE	MB	11.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.22		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4422	REV. A
TITLE SHIM	SCALE NTS
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